Date: Wednesday, 1/4/2006 7:30:32 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350 SKIDTUBE EXTRUSION (BENT)
Job Number	: 25384		
Estimate Number	: 10997		
P.O. Number	: N|A	**Part Number**	: D26003BENT
This Issue	: 1/4/2006 **S.O. No.** : N|A	**Drawing Number**	: D2600 REV D1
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N|A **Type** : MACHINED PARTS	**Drawing Revision**	: D1
Previous Run	: N|A	**Material**	: N|A
Written By	: _See Comment below_	**Due Date**	: 1/11/2006 **Qty:** 50 **Um:** Each
Checked & Approved By	: _See Comment below_		
Comment	: Est. B02.11.28 Reformat KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit   Total : 50.0000 Each(s)
Extrusion Bent
Pick:

Qty	Part Number	Description	Batch
1	D2600-3	Extrusion	B23201 Pm' 06-01-06 (50)

Seq. #:	Machine Or Operation:	Description :
2.0	BENDING	BENDING MACHINE

Comment: BENDING MACHINE
Deburr one end of extrusion
Drill #30 pilot holes using DT8689   } Pm^C 06-01-06 (50)
Open holes to 5/16" and deburr
Bend using CNC bending machine as per program 2750.C and Folio FT003.
Use 5/16 locator pin on buggy "A".   } Pm^C 06-01-09 (49)
 Check fit to Jig DT8150

Seq. #:	Machine Or Operation:	Description :
3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
Inspect work to Step 6 Ensure fit to Jig DT8150

06.01.16   P-T0

Seq. #:	Machine Or Operation:	Description :
4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: LG Pm^C 06-01-17 (49)

Form: rprocess

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WORK ORDER CHANGES

W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ⟨signature⟩ Date: 06/01/18

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action	Section B				
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
06.01.16	2	1 piece scrap – mat'l cracked in bender, Tiny air pocket in mat'l seemed to be the problem.	⟨initials⟩	Scrap: destroy, Inspect remaining extrusion for cracks after bending.	⟨signature⟩ 06.01.16	⟨signature⟩ 06.01.16	⟨signature⟩	⟨signature⟩ 06.01.16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	**Drawing Name:** 350 SKIDTUBE EXTRUSION (BENT)
Job Number: 25384	**Part Number:** D26003BENT

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

06/01/18

Job Completion

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries